

Work Order ID 98224

Monday, March 11, 2013 9:58:39 AM

98224

Page 1

Item ID: D4500-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bell Door Header, LH

Start Date: 3/11/2013 Start Qty: 4.00

Required Date: 3/15/2013 Req'd Qty: 4.00

Reference: REWORK

Cust Item ID:

Customer:

Approvals: Process Plan: *MJP*

Date: *13-3-11* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D4500

per Rev D

220

0.00

220

Mill Conv

Memo

0.00

Conventional Milling Machine

PULL FROM STOCK D4500-1 X 4 B# 87960 REV C AND REWORK TO REV D

MJP 13/03/13

230

QC5- Inspect part completeness to step on W/O

0.00

230

QC

Memo

0.00

Quality Control

2 13-03-14

DAS 09 2-89

240

Touch up alodine

0.00

240

HandFinish

Memo

0.00

Hand Finishing

2 KB 13-3-14

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Page 2

Item ID: D4500-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bell Door Header, LH

Start Date: 3/11/2013 Start Qty: 4.00

4 2

Cust Item ID:

Required Date: 3/15/2013 Req'd Qty: 4.00

4

Customer:

Reference: REWORK

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

QC7-Inspect Chemical Conversion Coat

0.00

250

QC

Memo

0.00

Quality Control

2

DAS
05 13-03-15

260

Spray Painting per QSI005 4.2

0.00

260

SprayPaint

Memo

0.00

Spray Painting

TOUCH UP PRIME TEMPO GREY

2

0

0

AS
13-3-15

270

QC1 Inspect Part Finish

0.00

270

QC

Memo

0.00

Quality Control

DAS
16
9-03 13/03/13

2

Work Order ID 98224

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Page 3

Item ID: D4500-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bell Door Header, LH

Start Date: 3/11/2013 Start Qty: 4.00

4 *Q*
4

Cust Item ID:

Required Date: 3/15/2013 Req'd Qty: 4.00

Customer:

Reference: REWORK

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

Identify as per dwg & Stock Location:

Med
Fab
AO

0.00

*13-03-19**2****280***

Packaging

Memo

0.00

Packaging

290

QC21- Final Inspection - Work Order Release

0.00

290

QC

Memo

0.00

Quality Control

*13/3/2013**ME*
13-3-19

Picklist Print

Monday, March 11, 2013 9:58:38 AM

Page 1

Work Order ID: 98224

Parent Item: D4500-1

Parent Item Name: Bell Door Header, LH

Start Date: 3/11/2013

Required Date: 3/15/2013

Start Qty: 4.00

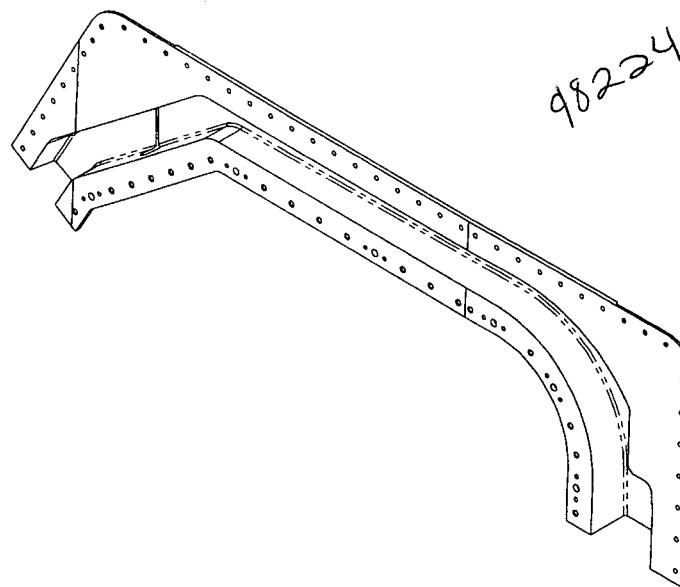
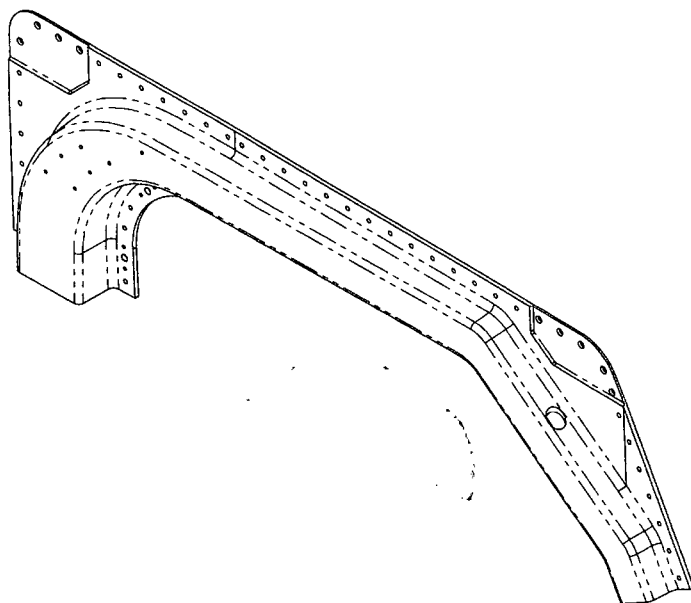
Required Qty: 4.00

Comments: IPP revA 12.07.18 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4500-1 Bell Door Header, LH		Manufactured	No				Each	0.0000					

87960

~~AO~~ 13-03-14
MJP



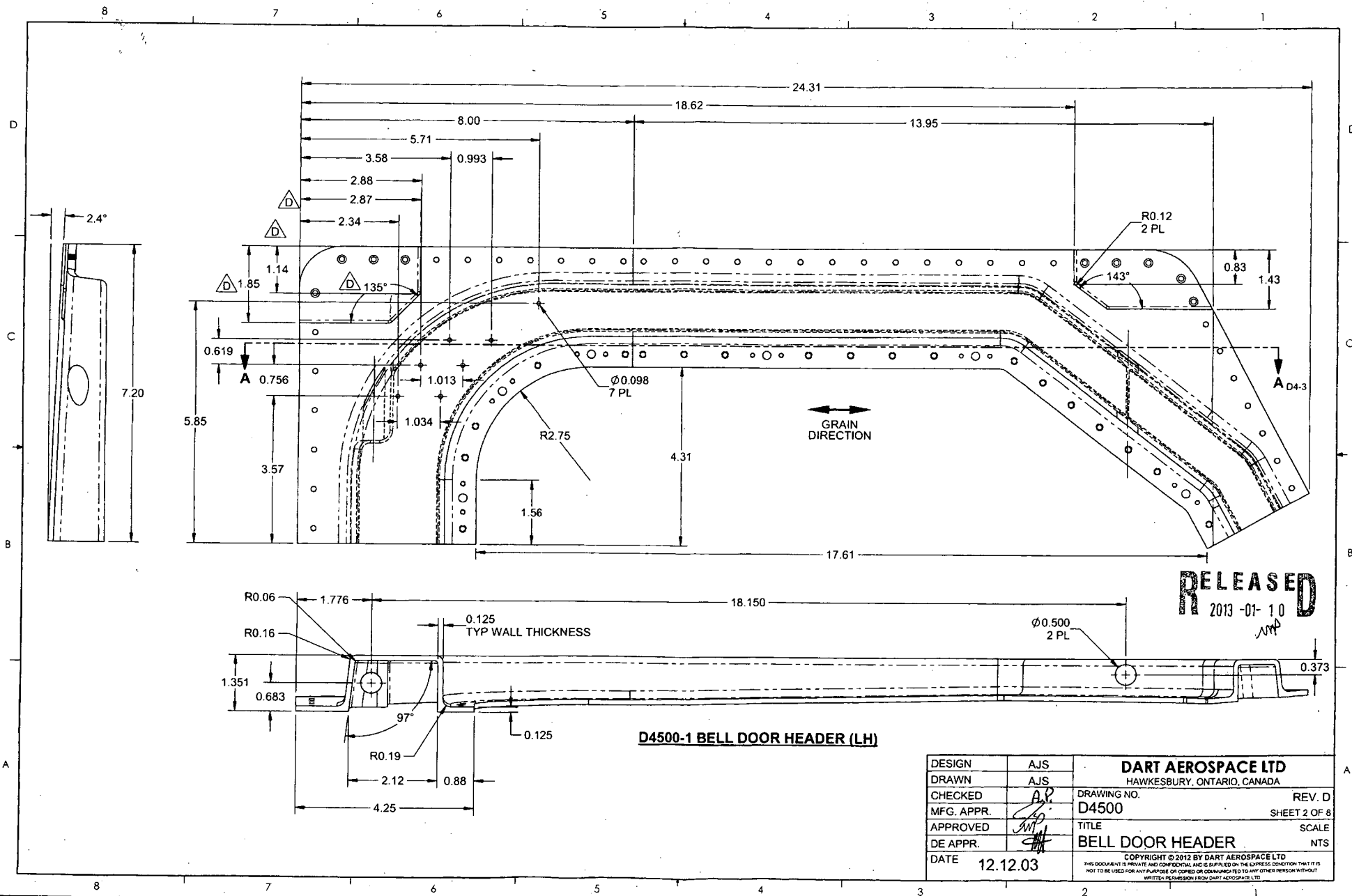
D4500-1 BELL DOOR HEADER (LH)

NOTES:

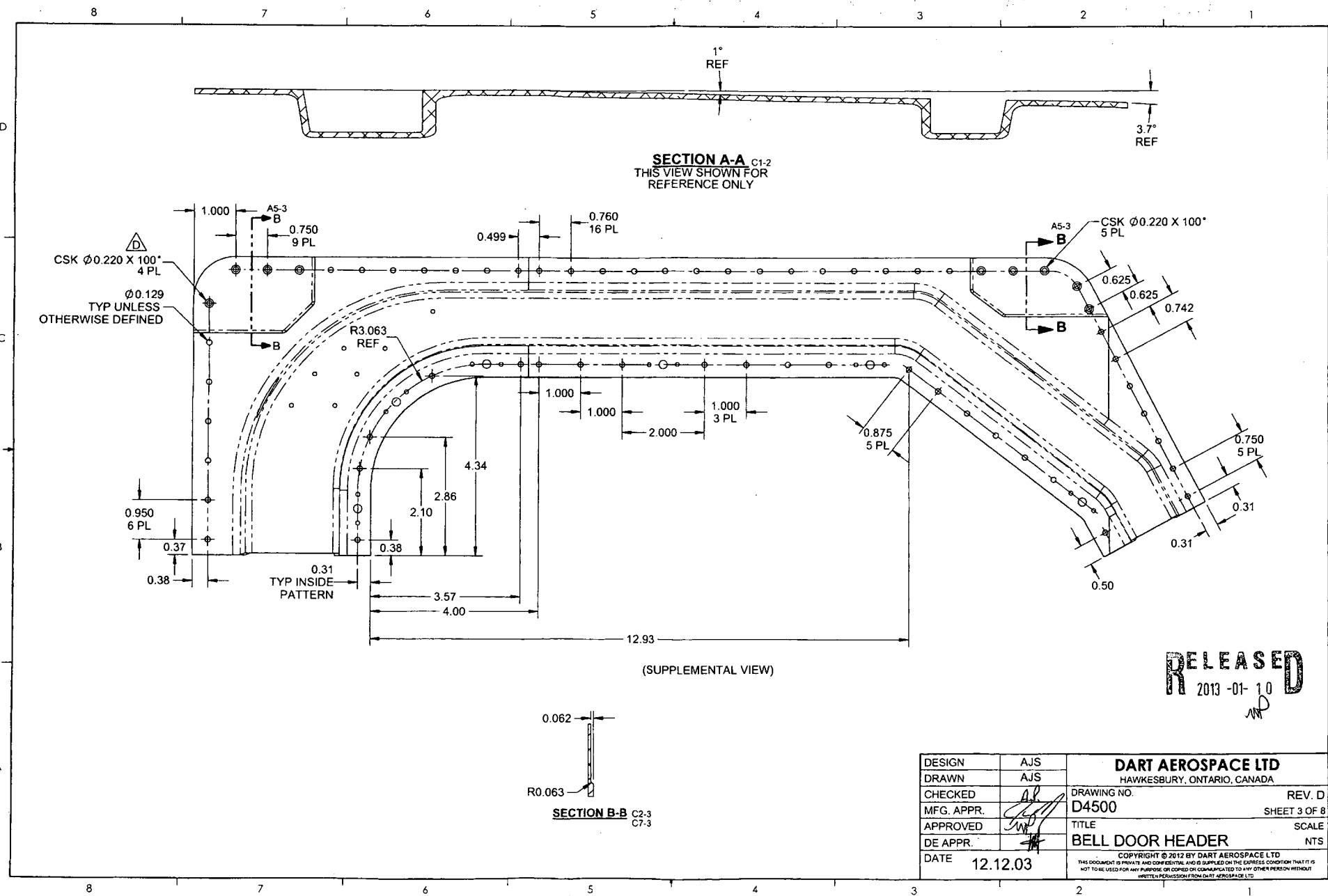
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8
(OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) RAW MATERIAL SURFACE FINISH SUFFICIENT FOR THIS PART
(NOT NECESSARY TO FACE MATERIAL).
- 9) ALL NON DIMENSIONED FEATURES PER CAD FILE "D4500-1-REV.D.STP"

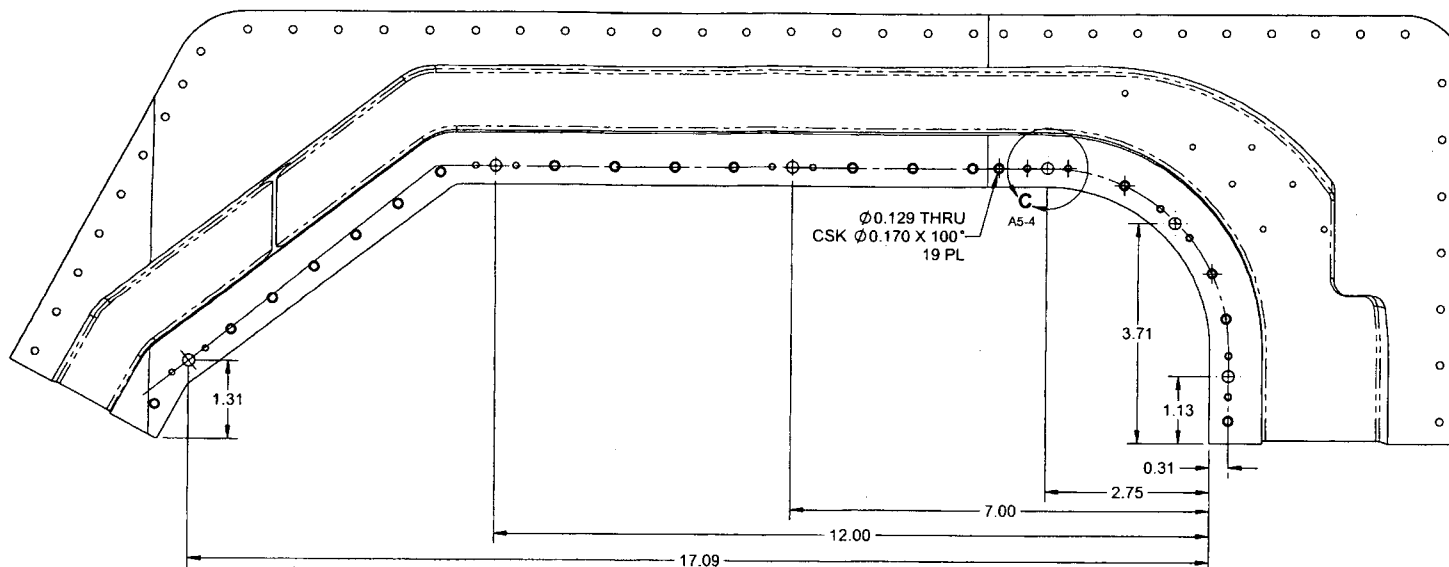
RELEASED
R 2013-01-10

D	SEE SHT 2 ZONE C6 POCKET ADDED TO AFT AREA OF FLANGE SIMILAR TO THE POCKET ON THE FWD AREA OF THE FLANGE. DONE TO FACILITATE OPERATION OF DOOR MECHANISM SAME POCKET ADDED TO -2 PART.	AJS	12.12.03
C	ADDED -2 (RH CONFIGURATION). B8-3 0.38 DIM TYP OUTSIDE PATTERN NOTE DELETED (DRAFTING ERROR). C4-4 Ø 0.129 THRU WAS Ø 0.225 (DRAFTING ERROR) CSK WAS 0.170. SEE DETAIL C Ø 0.201 HOLE WAS Ø 0.194 (EXPANDED FOR FLOATING NUTPLATE).	AJS	12.10.10
B	COMPLETE REDESIGN.	AJS	12.09.11
A	NEW ISSUE	AJS	12.03.02
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. D
MFG. APPR.	AP	D4500	SHEET 1 OF 8
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	BELL DOOR HEADER	NTS
DATE	12.12.03	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

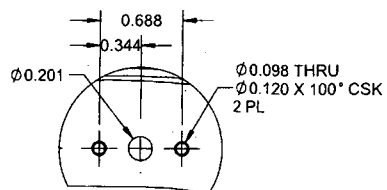


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DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. D
MFG. APPR.		D4500	SHEET 2 OF 8
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(SUPPLEMENTAL VIEW
NUTPLATE LOCATIONS)



DETAIL C C3-4
NUTPLATE HOLE DETAIL 6 PL
SCALE 2X

RELEASED
2013-01-10
WAP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AR</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>WJ</i>	D4500	SHEET 4 OF 8
APPROVED	<i>WJ</i>	TITLE	SCALE
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